**MATERIALS**

Flux: Flux type symbol "A" or "B" (flux type "L0" or "L1") in accordance with ANSI/J-STD-004 (previously designated as Type R or RMA only, in accordance with MIL-F-14256).

Solder: Sn60A or Pb40A or Sn63A or Pb37A in accordance with ANSI/J-STD-006 (previously designated as Sn 60 or Sn 63 in accordance with QQ-S-571).

Wire: Soft annealed solid copper.

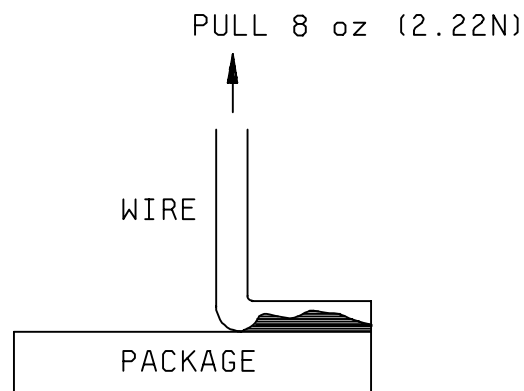


FIGURE 2004-2 Solder pad adhesion.